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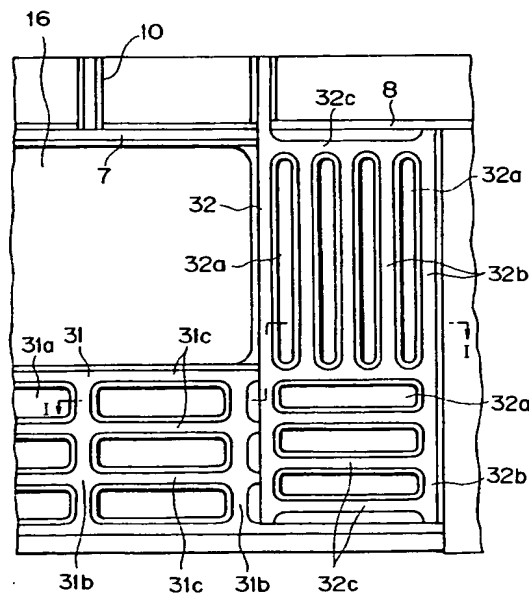
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(54) **Body structure for railway vehicle.**

(57) A side body structure for vehicles is formed of a plurality of sections. Each of the sections has a reinforcement in an integrally continuous construction. The reinforcement has a plurality of through holes which reduce total weight of the reinforcement. The reinforcement further includes a plurality of ribs formed around the holes and is securely placed together with a surface of an outer plate.

FIG. 1A



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BACKGROUND OF THE INVENTION

Field of the Invention

The present invention relates to the body structure of railway vehicles and enclosed girder bridges, constructed of press-formed frameworks.

Prior art

Figs. 13-14 show a side body structure for conventional vehicles. As shown in the figures, various posts such as a side entrance post 2, door end post 3, and side post 4 are vertically mounted relative to a horizontally laid rocker rail 1. Horizontally disposed between these posts are a window sill 5, a door pocket window sill 6, a frieze 7, and a door header 8. Further, a door pocket post 9 and a frieze frame 10 are vertically provided relative to the aforementioned horizontally disposed members. The above mentioned members are welded together to complete the framework of a side body structure. Substantially entire surface of the thus made framework are then covered with an outer plate 11, a door pocket window outer plate 12, a door pocket window sill 13, a door pocket window outer plate sill 14, and a frieze outer plate 15, which are welded reinforcements 11 and 12 thereto. In this manner, a side body structure having a window 16 is completed.

Fig. 15 shows an example of an end body structure provided at the front and rear bridges of a railway vehicle. The end body structure has a pair of end entrance posts 17 and 17 on the left and right sides of the end entrance, and vertically provided corner posts 18 and 18. Between these posts are disposed a plurality of members such as a door header 19, an end rocker rail 20, and a cross beam 21. An arch shaped beam 22 is disposed on the posts 17 and 18 and an end outer plate 23 is welded on the upper end body structure. In this manner, the end body structure is completed.

Japanese Patent Preliminary Publication No.61-220962 discloses a structure in which a flat side outer plate and a reinforcement having an uneven surface are put together to form a side body structure. The reinforcing plates has relatively small projections transversely thereof, i.e., beads, a cross section of which being a triangle, and projections having a U-shaped cross section longitudinally of the projections. The reinforcing plate may have an uneven surface with rectangular projections thereon and a core material is filled between the side outer plate and the reinforcement.

Japanese Patent Preliminary Publication No.61-220963 discloses a structure in which bead is formed on pier panels between side posts and cross members in the direction of a shear force.

Such conventional structures have drawbacks

in that the side body structure requires a large number of components of and many kinds, more preparatory works when machining, and complex work operations. The conventional structures also require a large number of jigs for positioning the respective members relative to each other, and is complex in getting all necessary parts ready for assembly work. In addition, welding must be carried out at many portions, being sources of increased mechanical strains and less dimensional precision.

According to the aforementioned Japanese Patent Preliminary Publications, No.61-220962 and 61-220963, bead is used to form uneven surfaces. However, the projections provided by the bead are rather small, being less effective. Japanese Preliminary Publication No.61-220962 requires an additional work of filling the core material between the projections and the outer plate.

SUMMARY OF THE INVENTION

The present invention was made in view of the aforementioned drawbacks and an object of the present invention is to provide a side body structure of a vehicle which requires less number of parts, simplified part-machining and assembly operation, and insures required rigidity, lighter weight, and less dimensional distortion.

A side body structure for vehicles according to the invention is formed of a plurality of sections. Each of the sections has a reinforcement in an integrally continuous construction. The reinforcement has a plurality of through holes which reduce total weight of the reinforcement. The reinforcement further includes a plurality of ribs formed around the holes and is securely placed together with a surface of an outer plate.

BRIEF DESCRIPTION OF THE DRAWINGS

Features and other objects of the invention will now be more apparent from the description of the preferred embodiments with reference to the accompanying drawings in which:

Fig. 1 shows a first embodiment of a side body structure for a vehicle according to the present invention, Fig. 1A is a side view of the body structure seen from the passenger space of a vehicle, and Fig. 1B is a side view of the body structure seen from the outside of the vehicle; Fig. 2A is a cross-sectional view taken along the lines G-G of Fig. 1, Fig. 2B is a cross-sectional view taken along the lines H-H of Fig. 1, Fig. 2C is a cross-sectional view taken along the lines I-I of Fig. 1;

Fig. 3 shows an end body structure as a second embodiment of invention, Fig. 3A is a rear view

of the end body structure seen from the passenger space, Fig. 3B is a front view of the end body structure of Fig. 3A seen from the outside of the vehicle, Fig. 3C is cross-sectional views taken along the lines J-J of Figs. 3A and 3B, Fig. 3D is a cross-sectional view taken along the lines K-K of Fig. 3A, and Fig. 3E is a cross-sectional view taken along the lines L-L of Fig. 3A;

Fig. 4 shows a third embodiment, Fig. 4A is a side view of the third embodiment seen from the passenger space, and Fig. 4B is a side view of the third embodiment seen from the outside of the vehicle;

Fig. 5 is a rear view of a fourth embodiment seen from the passenger space;

Fig. 6 is a fragmentary rear view, expanded in part, of the sill plate 102 of Fig. 5;

Fig. 7 is a simplified cross-sectional view taken along the lines IV-IV of Fig. 6;

Fig. 8 is a cross-sectional view taken along the lines III-III of Fig. 5;

Fig. 9 is a front view of part of a plate-like material before it is plastically deformed;

Fig. 10 is a horizontal cross-sectional view of the fourth embodiment showing the sill 102 secured to a post 120;

Fig. 11 is an expanded rear view of part of a fifth embodiment of the invention;

Fig. 12 shows a sixth embodiment, Fig. 12A showing the directions of forces acting on the wainscot, Fig. 12B being a fragmentary expanded view of the wainscot having holes aligned in parallel, and Fig. 12C being a fragmentary expanded view of holes aligned in zigzag fashion;

Fig. 13 shows a conventional side body structure, Fig. 13A is a rear view of the body structure seen from the passenger space, Fig. 13B is a front view of the body structure of Fig. 13A seen from the outside of the vehicle;

Fig. 14A is a cross-sectional view taken along the lines A-A of Fig. 13B, Fig. 14B is a cross-sectional view taken along the lines B-B of Fig. 13B, Fig. 14C is a cross-sectional view taken along the lines C-C of Fig. 13A;

Fig. 15 shows a conventional end body structure, Fig. 15A is a rear view of the end body structure seen from the passenger space, Fig. 15B is a front view of Fig. 15A seen from the outside of the vehicle, Fig. 15C is a cross-sectional view taken along the lines D-D of Figs. 15A and 15B, Fig. 15D is a cross-sectional view taken along the lines E-E of Fig. 15A, and Fig. 15E is a cross-sectional view along the lines F-F of Fig. 15A.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENT

First Embodiment

A first embodiment of the invention will now be described in detail with reference to the drawings.

Figs. 1 and 2 show a side body structure according to the invention. A side body structure of a vehicle is constructed of a plurality of sections. The rocker rail 1, a side post 4, a window sill 5, and a reinforcement 11 of the prior art structure are formed of metal into a wainscot frame 31 in an integrally continuous construction as a section. A plurality of holes 31a are made in the section so as to reduce overall weight of the structure. Around the holes are formed longitudinal ribs 31b which are in place of the conventional door end posts 3 and side posts 4, and transverse ribs 31c which are in place of the conventional window sill 5 and reinforcement 11.

Likewise, the side entrance post 2, door end post 3, door pocket post 9, reinforcement 11 and 12 and door pocket window sill 6 of the prior art structure are formed of metal into a door pocket frame 32 as a section in an integrally continuous construction. The door pocket frame is formed with longitudinally elongated holes and transversely elongated holes therein around which longitudinally extending ribs 32b and transversely extending ribs 32c are formed, respectively. Above the respective sections 31 and 32 are formed a frieze 7, a door header 8, and a frieze frame 10 connected together so as to form a framework of a side body structure just as in the conventional side body structure. Then, a sill outer plate 13, a door pocket outer plate 14, and a frieze outer plate 15, which are similar to those of the conventional side body structure, are mounted on the respective sections. The outer plates 13, 14, and 15 may also be formed in one piece structure. The respective sections 31 and 32 are connected together by, for example, welding before the outer plates 13, 14, and 15 is mounted to complete a side body structure primarily used for vehicles.

Second Embodiment

Fig. 3 shows an end body structure as a second embodiment of a side body structure of the invention.

The end entrance post 17, a corner post 18, end rocker rail 20, cross beam 21, one end of arch shaped beam 22 of the prior art are formed through press into an end wall frame 33 of an integrally continuous construction. Two end wall frames 33 are connected together with an end entrance upper frame 34 therebetween. The end wall frame 33 is also formed with through holes 33a therein just as other sections are formed holes therein. Around the holes 33a are formed with

vertically extending ribs 33b and horizontally extending ribs 33c. Likewise, the end entrance upper frame 34 is formed with a through hole 34a and a rib 34b. Mounting an end outer plate 23 on the assembly of two end wall frames 33 and an entrance upper frame 34 completes the end body structure.

Third Embodiment

The arrangement of ribs of the invention are not limited to the longitudinal and transverse direction. Fig. 4 shows a third embodiment, where the wainscot frame 31 and door pocket frame 32 are provided with ribs 31d, 31e, 32d, and 32e that operate as diagonal beams. These ribs increase rigidity of the vehicle in the back and forth direction of the vehicle. The ribs 31d and 31e may be combined with the longitudinal and transverse ribs 31b and 31c in Fig. 1. The ribs may be arranged such that their longitudinal axes cross each other regardless of whether the ribs are actually crossing each other.

Fourth Embodiment

Fig. 5 is a simplified rear view of a fourth embodiment seen from a passenger space 1. A side body structure 101 is formed of a sill plate 102, a door pocket plate 103, and a frieze plate 104. The side body structure 101 has a side window 105 and side entrance 106.

Fig. 6 is a fragmentary rear view of the sill plate 102 expanded in part. Fig. 8 is a cross-sectional view of the sill plate 102 taken along the line III-III of Fig. 5. A reinforcement 108 is formed with a plurality of elongated holes 109 therein and is secured to the surface on the side of passenger space (right hand side in Fig. 8) of outer plate 107. The outer plate 107 and the reinforcement 108 are made of metal such as stainless steel.

Flanges 110 and 111 are formed around the hole 109 and are secured at 115 and 116 to the passenger side surface of the outer plate 107 through, for example, spot welding. The reinforcement 108 has a beveled portion 112 integrally continuous with the flanges 110 and with a reinforcing portion 113 between two beveled portions. Similarly, flanges 111 is integrally continuous with the reinforcing portion 113 via beveled portions 114.

Fig. 7 is a cross-sectional view taken along the lines IV-IV of Fig. 6. Arcuate cutouts 118 continuous with the hole 109 are formed at corners of substantially rectangular hole 109 in the proximity of the beveled portions 112 and 114 and flanges 110 and 111, so that inwardly curved beveled portions 109 are formed when a flat sheet of metal

108 in Fig. 9 is press-worked. Fig. 9 shows the flat shaped reinforcement 108 before it is subjected to plastic deformation into that shown in Fig. 8.

It should be noted that a hole 109 and a cutout 118 are formed near the flanges 110 and 111.

The flanges 110 and 111 and beveled portions 112 and 114 are bent by pressing while the beveled portion 119 near the cutout 118 is formed by drawing. The cutouts 118 is provided so as to prevent wrinkles or cracks due to tensile force acting thereon when the reinforcement is drawn. If the reinforcement has good malleability, then the cutout 118 is not required.

Fig. 10 is a horizontal cross-sectional view of the sill plate 102 and the vicinity thereof.

The sill plate 102 is spot-welded at the flange 110 of reinforcement 108 to a post 120. Then an interior plate 121 is, for example, bolted to the post 120 to define the passenger space.

Fifth Embodiment

Fig. 11 is an expanded front view of a fifth embodiment. A flange 110a is formed only at a portion where the reinforcement 108 is spot-welded to the outer plate 107. The fifth embodiment is advantageous in reducing total weight and saving the costs of material. The outer plate 107 may be made not only of metal such as a sheet of stainless steel but also of other materials such as synthetic resin and FRP (fiber reinforced plastics). The outer plate and the flanges of reinforcement may be connected together by, for example, spot welding, riveting, adhesives, and a fastener such as bolt and nut.

Sixth Embodiment

Fig. 12 shows a sixth embodiment of the invention. Fig. 12A shows directions of forces exerted to the wainscot 202 when the vehicle body is supported on the bogies at arrows M, Fig. 12B is a view, expanded in part, of the wainscot having elongated holes aligned in parallel with each other, and Fig. 12C is a view, expanded in part, of the wainscot having elongated holes aligned in zigzag arrangement.

If the wainscot 202 has elongated holes aligned in the direction of applied forces, then the wainscot 202 may buckle at "D" when compressive forces are applied in the direction of arrows F. The buckling of the wainscot 202 as well as the outer plate placed together with the wainscot may be prevented by arranging the elongated holes in zigzag fashion with the holes elongated in the direction of applied forces. In this manner, the mechanical strength of side body structure is enhanced.

Industrial Applicability

Each section of a side body structure may be formed in an integrally continuous construction by the use of press, which has a relatively high degree of freedom in making a variety of shapes of a structure. The integrally continuous construction of the respective sections reduces the number of parts and time required for assembling the sections, improving productivity. Ribs may be formed in a variety of shapes and diagonal beams may be formed, if necessary, for more rigidity of the section.

The lighter weight of the side body structure is implemented by pressing a light, thin plate through which holes are punched through. Further, preprocessed portions of the respective sections may easily be formed in proper shapes before the sections are finally connected together.

The frame of side body structure is constructed of large size sections which allows least strain, least dimensional error, and ease of manufacture of side body structure. In addition, the thus completed vehicle body will have lighter weights, sufficient rigidity against loads exerted, and good appearance.

Providing ribs improves the modulus of section and the second moment of area, so that rigidity against out-of-plane bending and in-plane bending is increased.

The sill plate 102 withstands large axial forces in the longitudinal direction (leftwards and rightwards in Figs. 5 and 6) of the hole 109, improving the buckling strength of a body structure. The reinforcement provided around the holes improves the rigidity of the respective sections against compression forces exerted at right angles with respect to the longitudinal length of the holes 109. Meanwhile, the portions without reinforcement are rather flexible preventing plastic deformation which may be caused by compressive forces.

The corner portions of the hole 109 has beveled portions 119 which have been rather rounded through drawing into a so-called three dimensional shape which withstands particularly a large torsional force exerted to the entire section, so that crippling will not result.

A cutout 118 formed near the beveled portion 119 enables the flat sheet of metal as shown in Fig. 9 to be pressed with a relatively small force. Thus, there is no need for good malleability of the material.

A plurality of elongated holes are arranged in rows extending in a direction of exerted forces such that each elongated hole is positioned between adjacent two elongated holes in adjacent row. This zigzag arrangement is particularly advantageous in increasing mechanical strength of

wainscot against bucking forces.

Claims

1. A side vehicle body structure having a plurality of sections connected together to form an entire said body structure, each of the sections comprising:
 - a reinforcement formed in an integrally continuous construction;
 - a plurality of holes formed in said section so as to reduce a weight thereof;
 - a plurality of ribs formed around said holes; and
 - an outer plate securely placed together with a surface of said section.
2. A vehicle body structure according to Claim 1, wherein said plurality of sections are made of metal.
3. A vehicle body structure according to Claim 1, wherein said plurality of sections are spot-welded to said outer plates.
4. A vehicle body structure according to Claim 1, wherein said plurality of sections are made of synthetic resin.
5. A vehicle body structure according to Claim 1, wherein said plurality of sections are made of fiber reinforced plastics.
6. A vehicle body structure according to Claim 1, wherein said holes are rectangular and said ribs are formed to extend into said holes to diagonally cross each other.
7. A vehicle body structure according to Claim 1, wherein said ribs include ribs in row and ribs in file.
8. A vehicle body structure according to Claim 2, wherein said ribs are formed by deforming a peripheral portion of said hole through drawing.
9. A vehicle body structure according to Claim 8, wherein said hole is substantially rectangular and has cutouts at four corners thereof, said peripheral portion including said cutouts is deformed by drawing so to form said ribs.
10. A vehicle body structure according to Claim 1, wherein said ribs have flanges in contact with said outer plate when assembled and extending to define said hole; and reinforcement integrally continuous with said flanges and positioned away from said outer plate when said

section is connected to said section.

11. A vehicle body structure according to Claim 1, wherein said holes are elongated holes in rows extending in a direction of applied loads, said holes being arranged in zigzag such that each hole is positioned between adjacent two holes in adjacent row.

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FIG. 1A

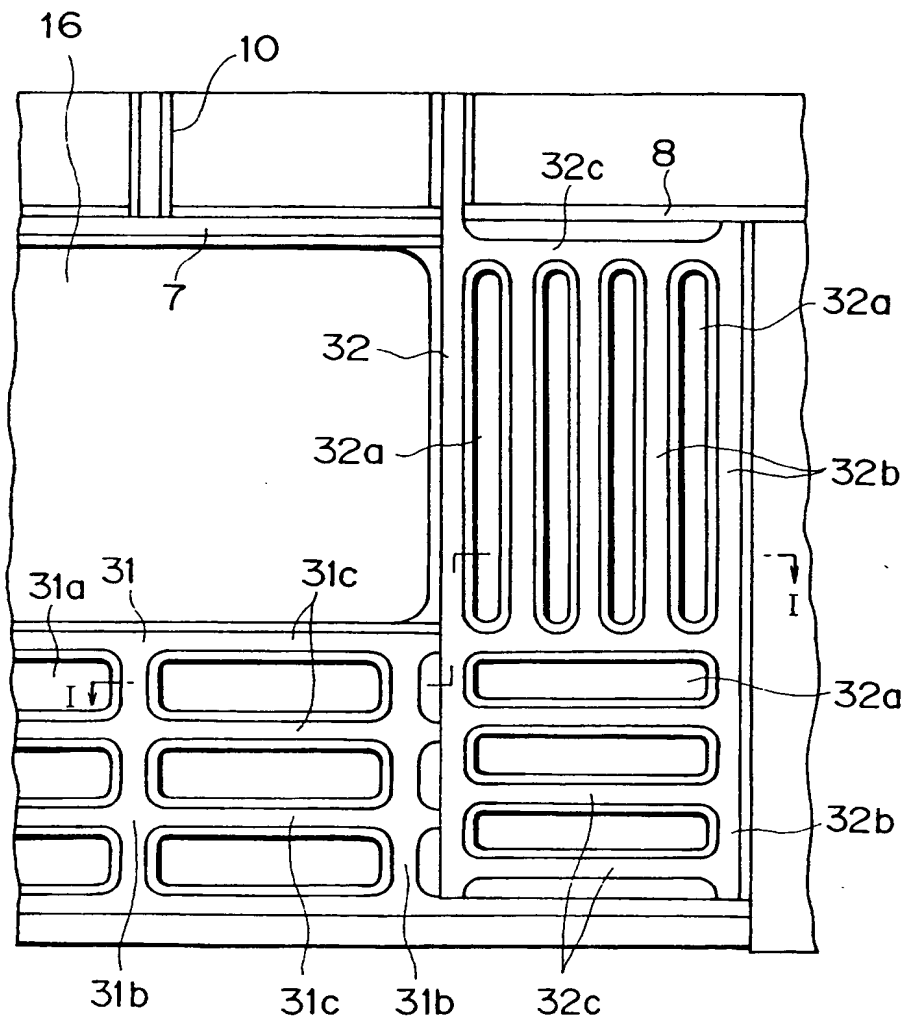


FIG. 1B

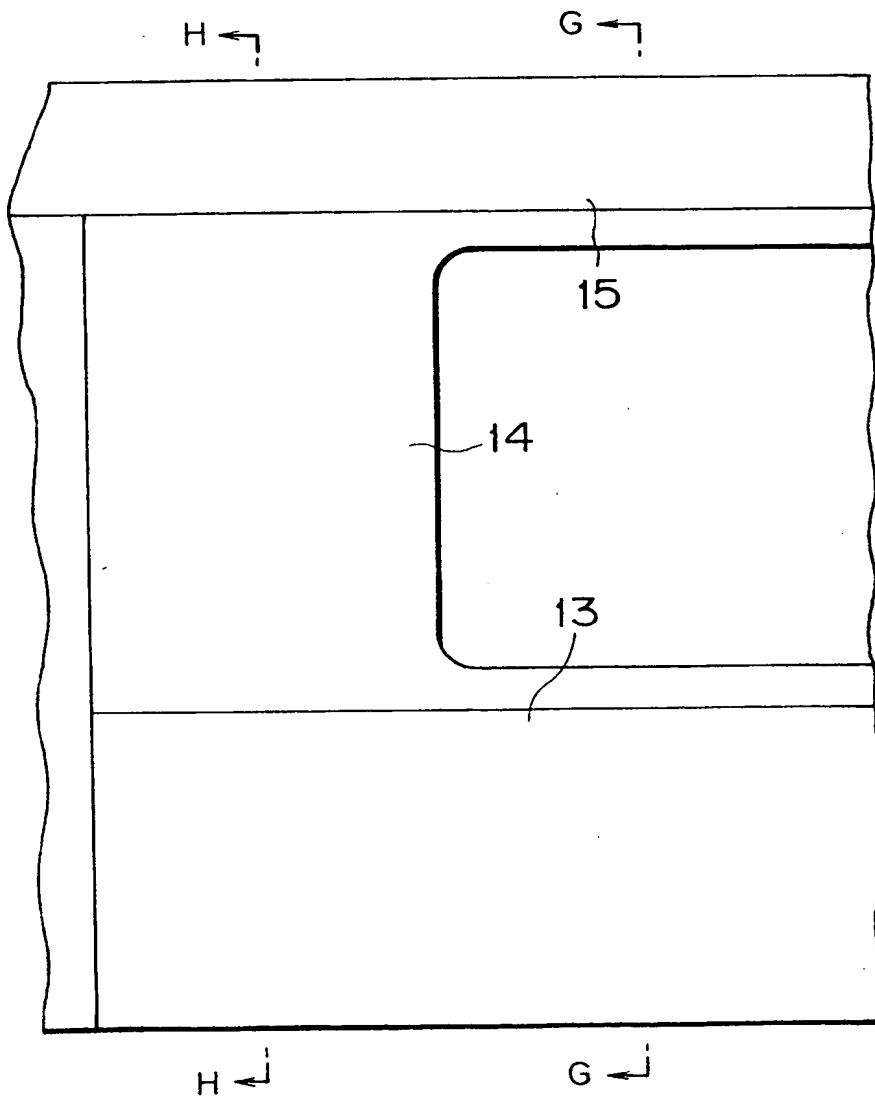


FIG.2A FIG.2B

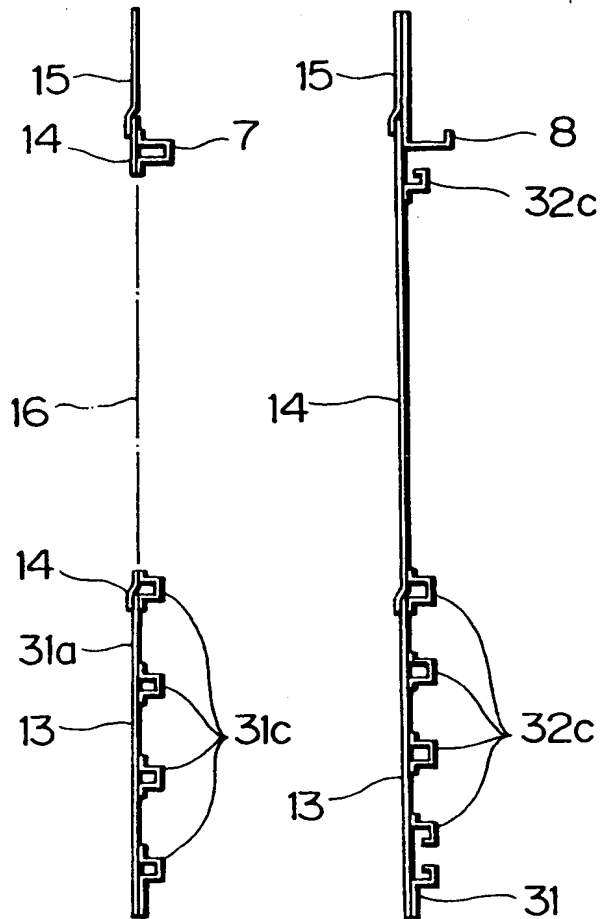


FIG.2C

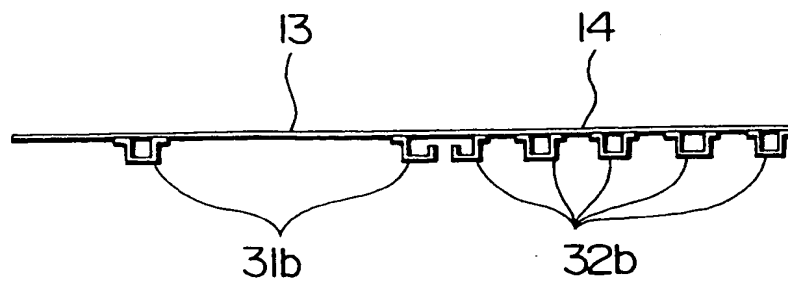


FIG. 3B

FIG.3A

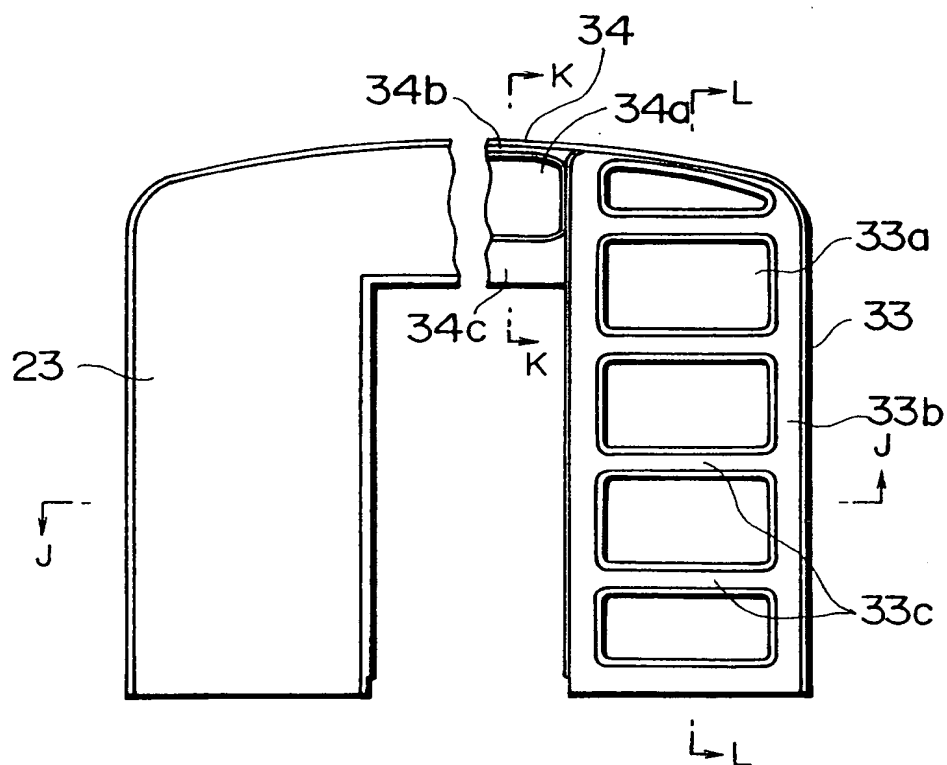


FIG. 3C

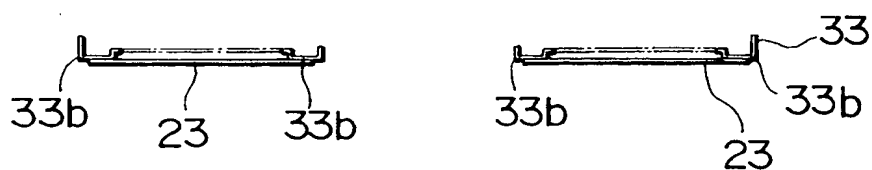


FIG.3D

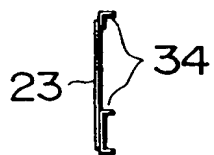


FIG.3E

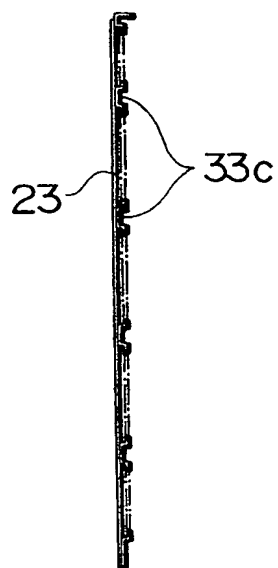


FIG. 4A

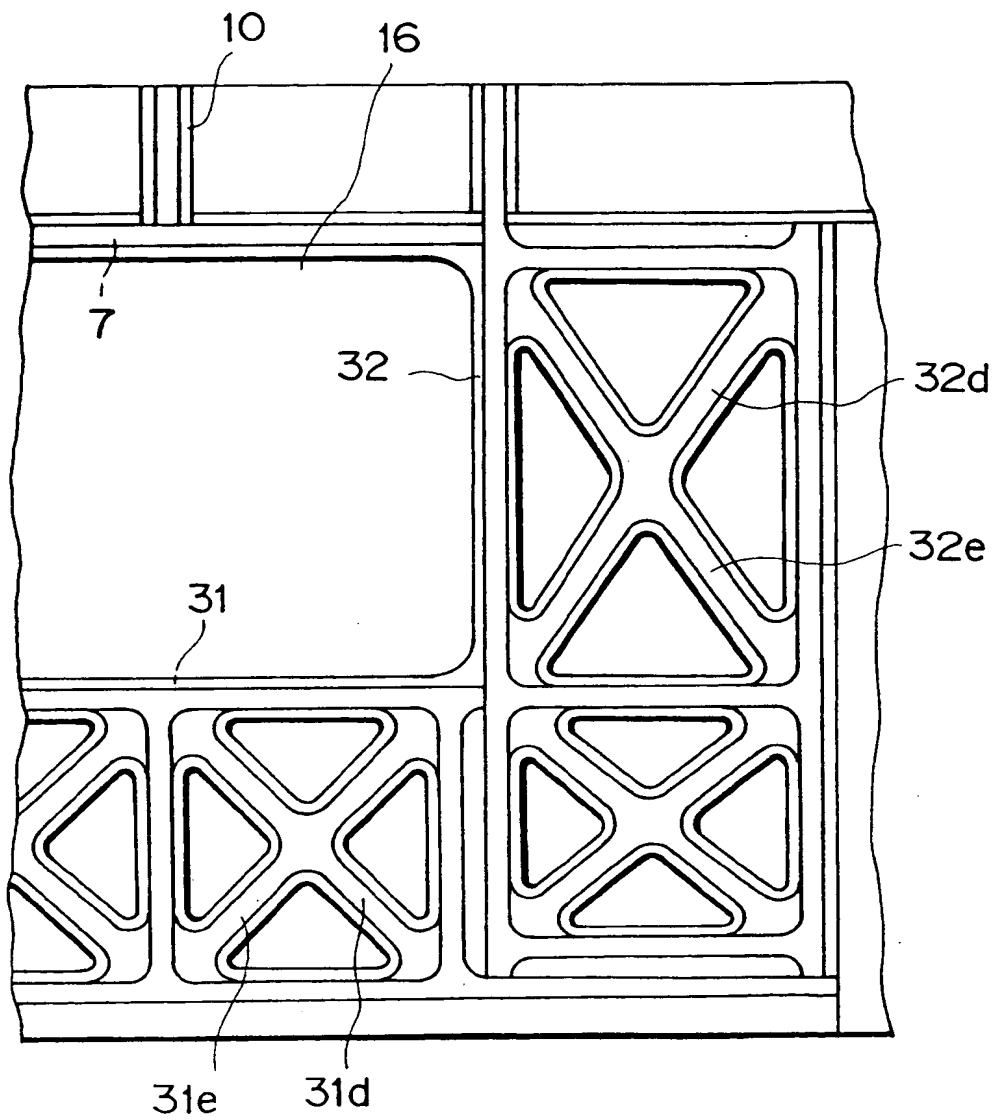


FIG. 4B

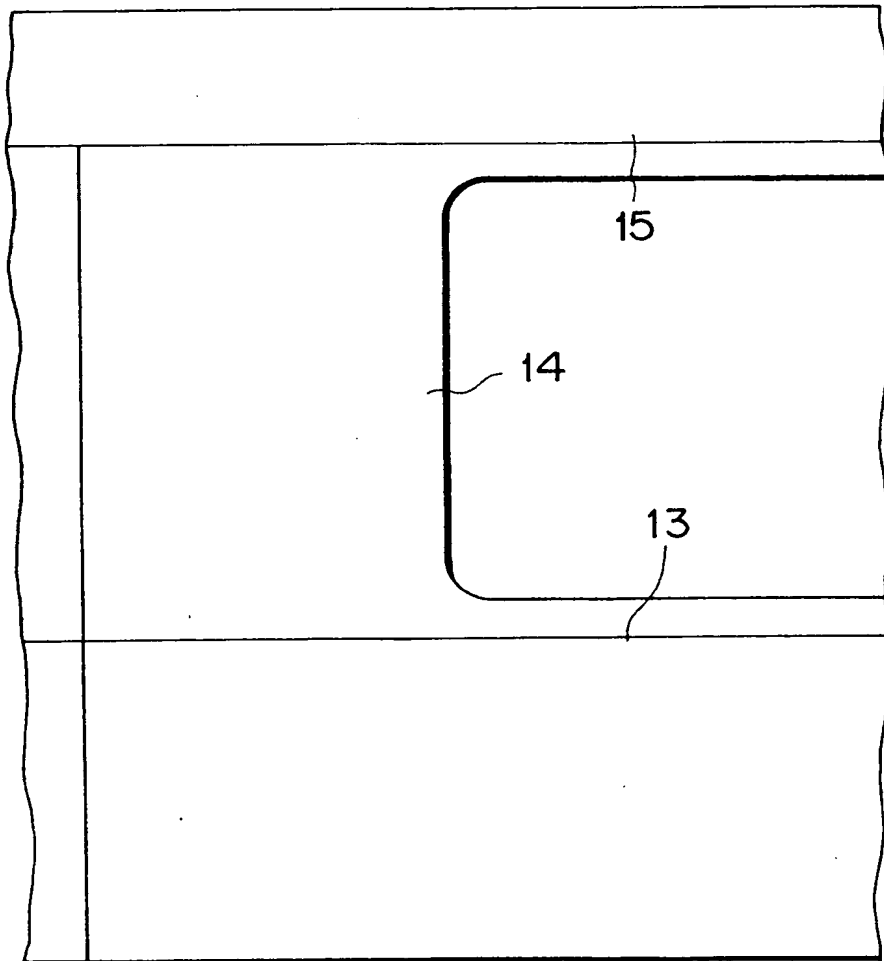


FIG. 5

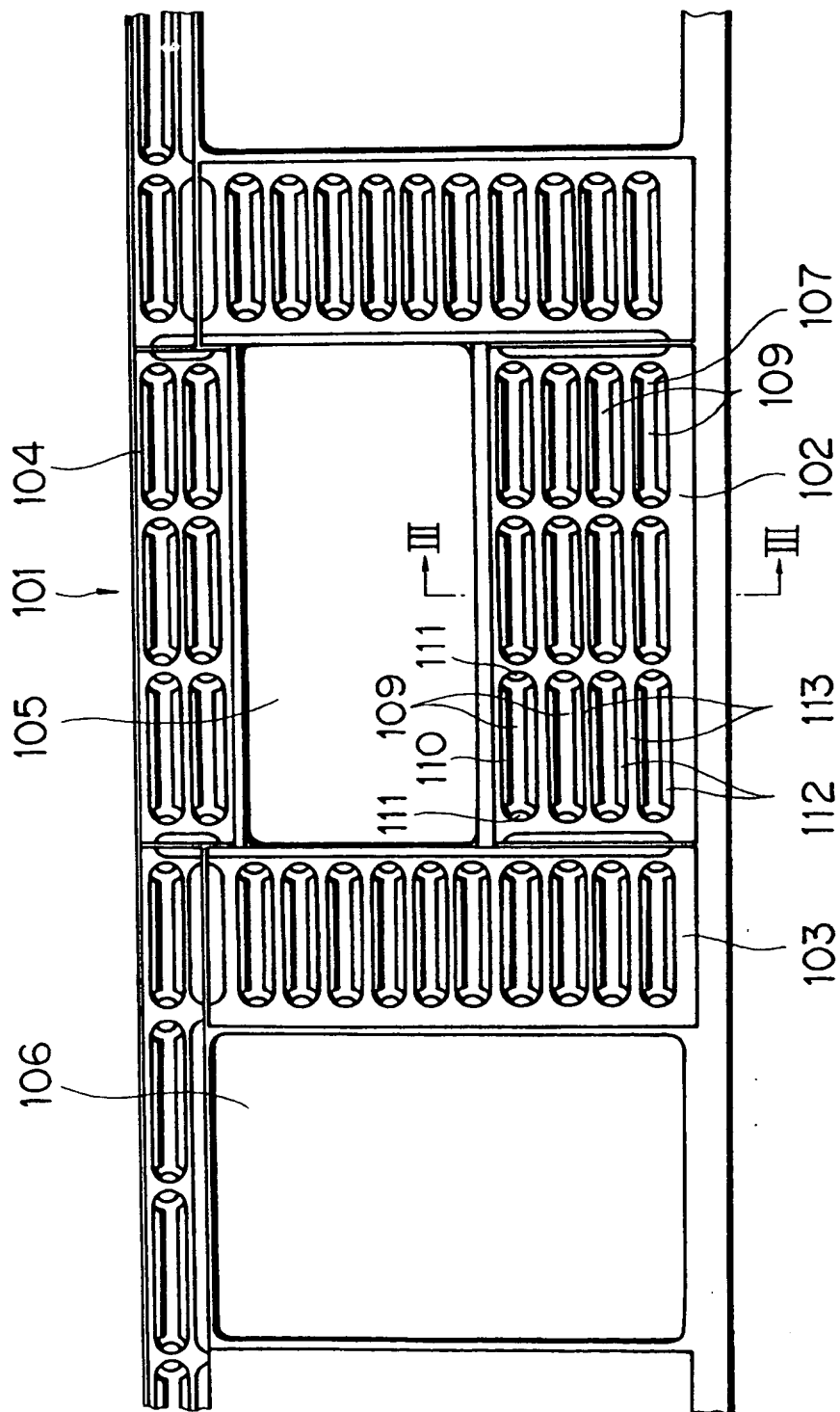


FIG. 6

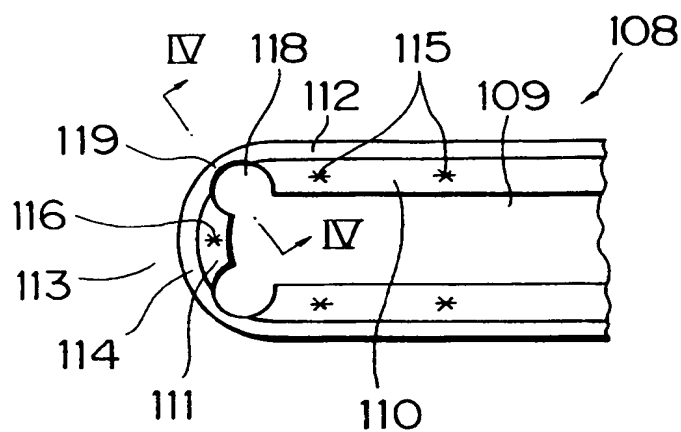


FIG. 7

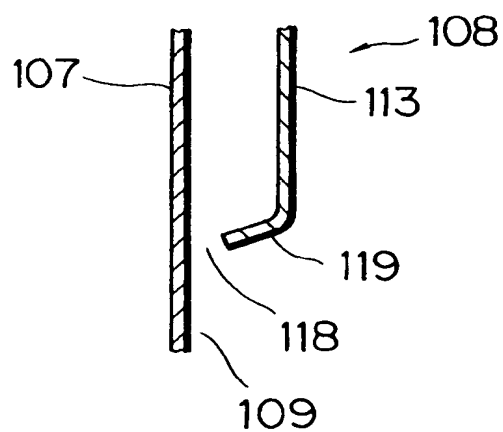


FIG. 8

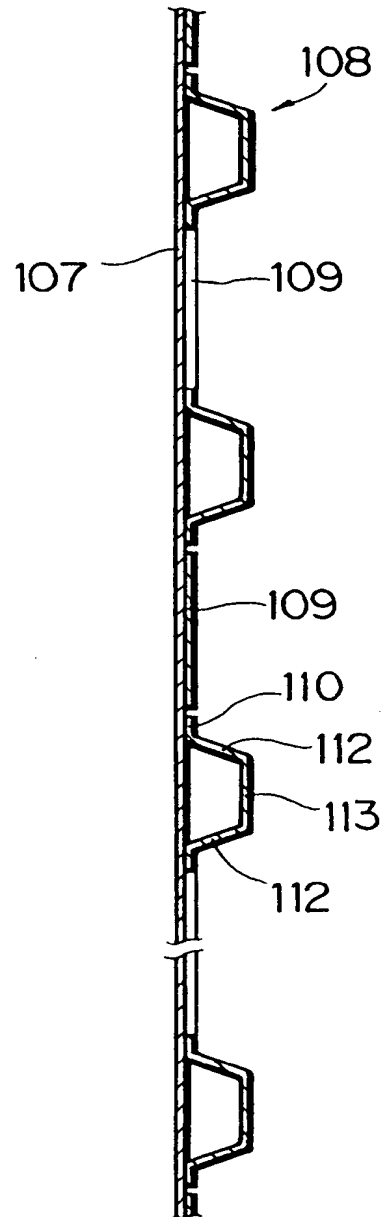


FIG. 9

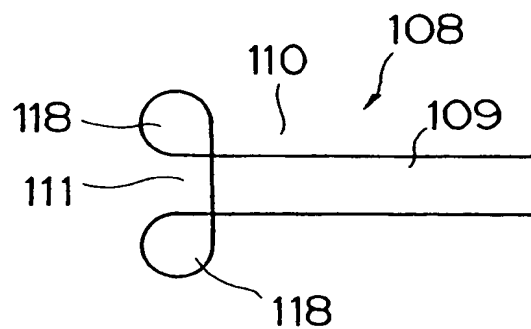


FIG. 10

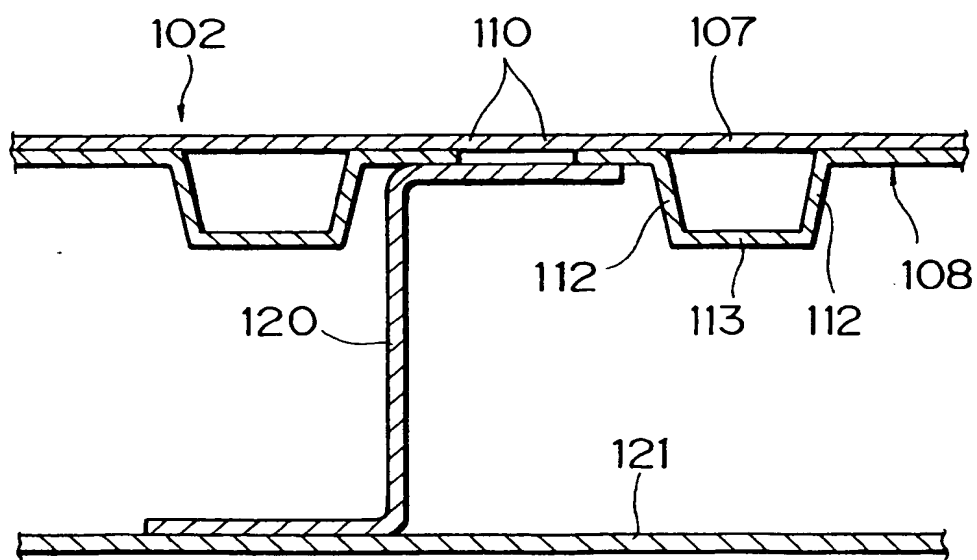


FIG. 11

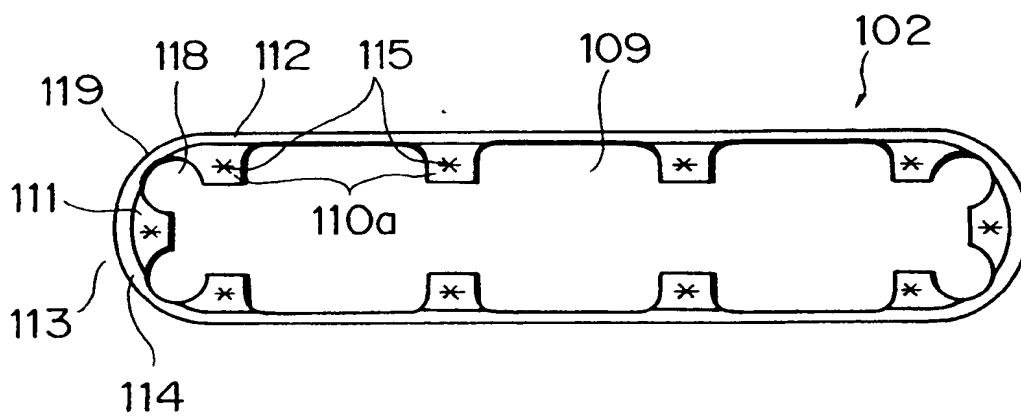


FIG. 12A

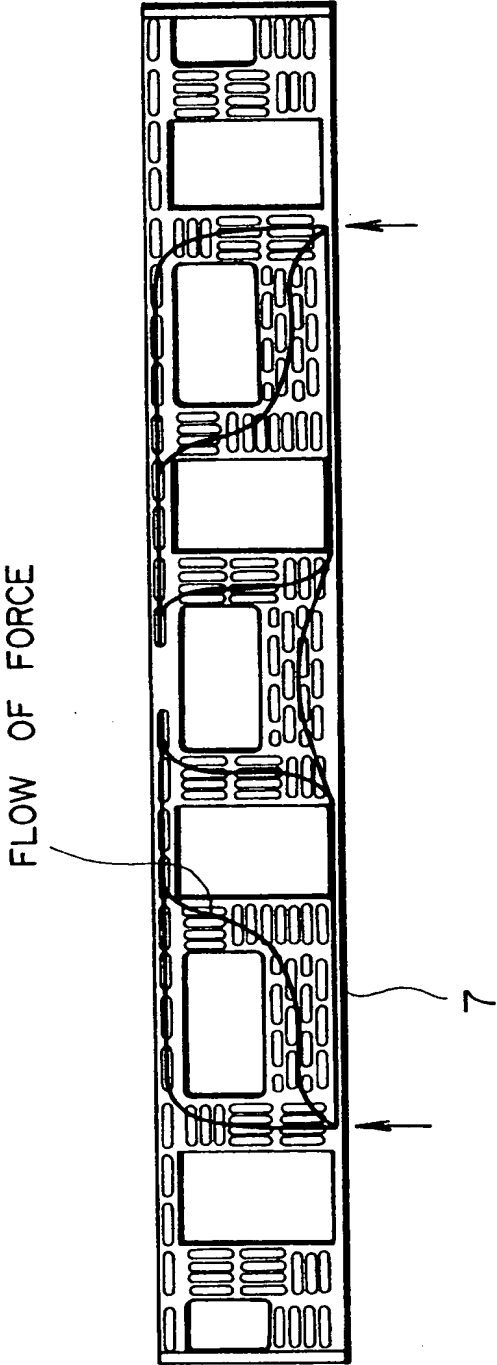


FIG.12B

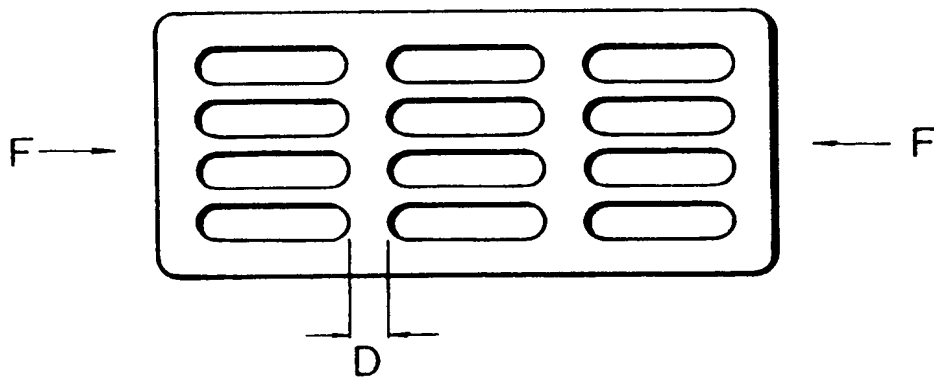


FIG.12C

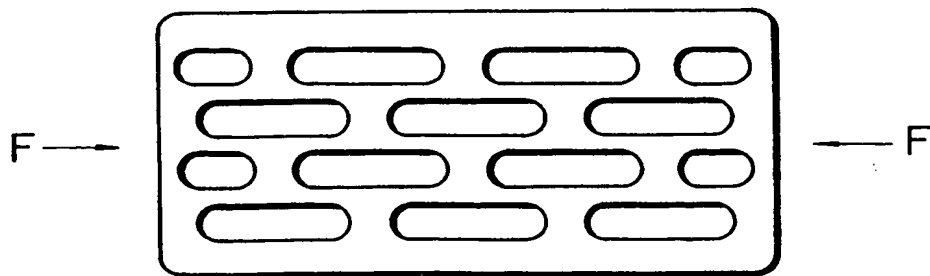


FIG.13A
PRIOR ART

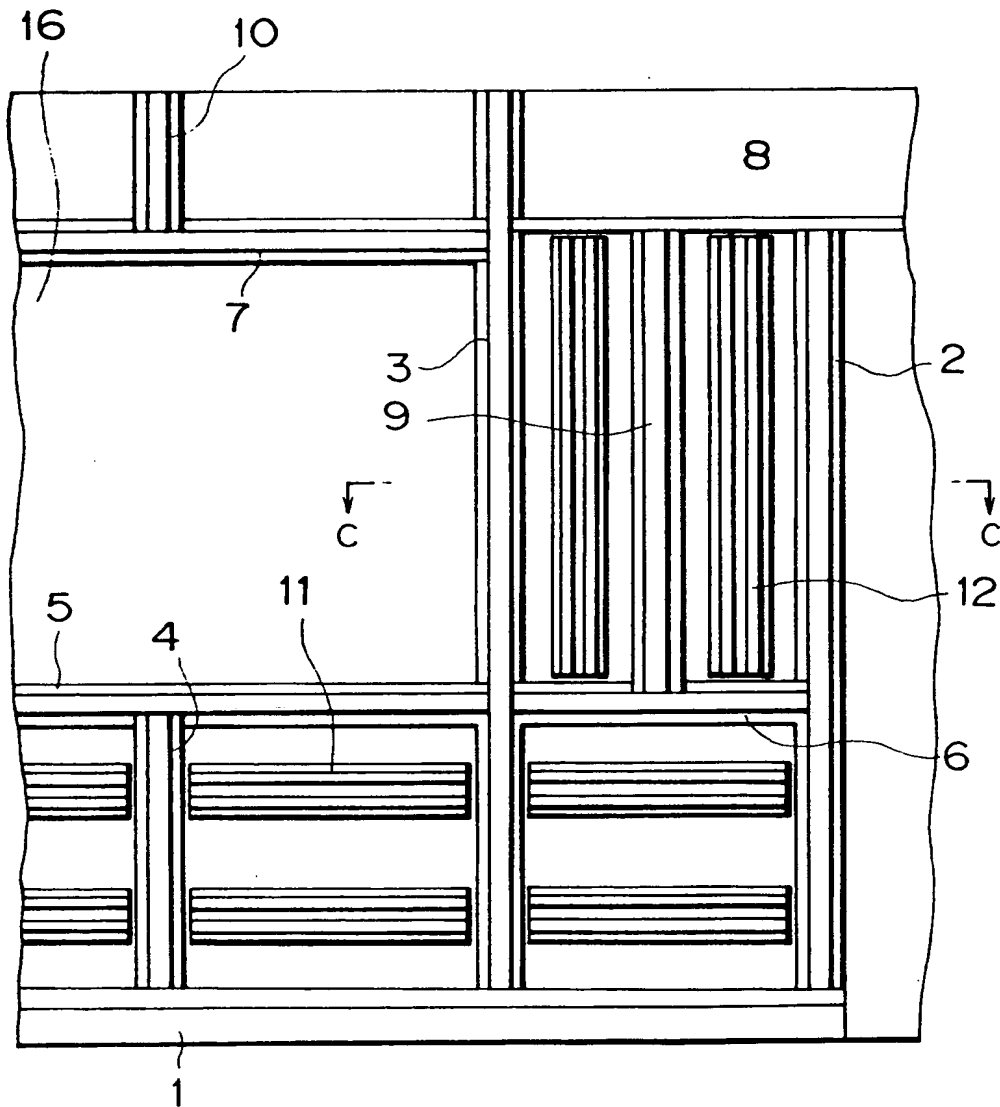


FIG. 13B

PRIOR ART

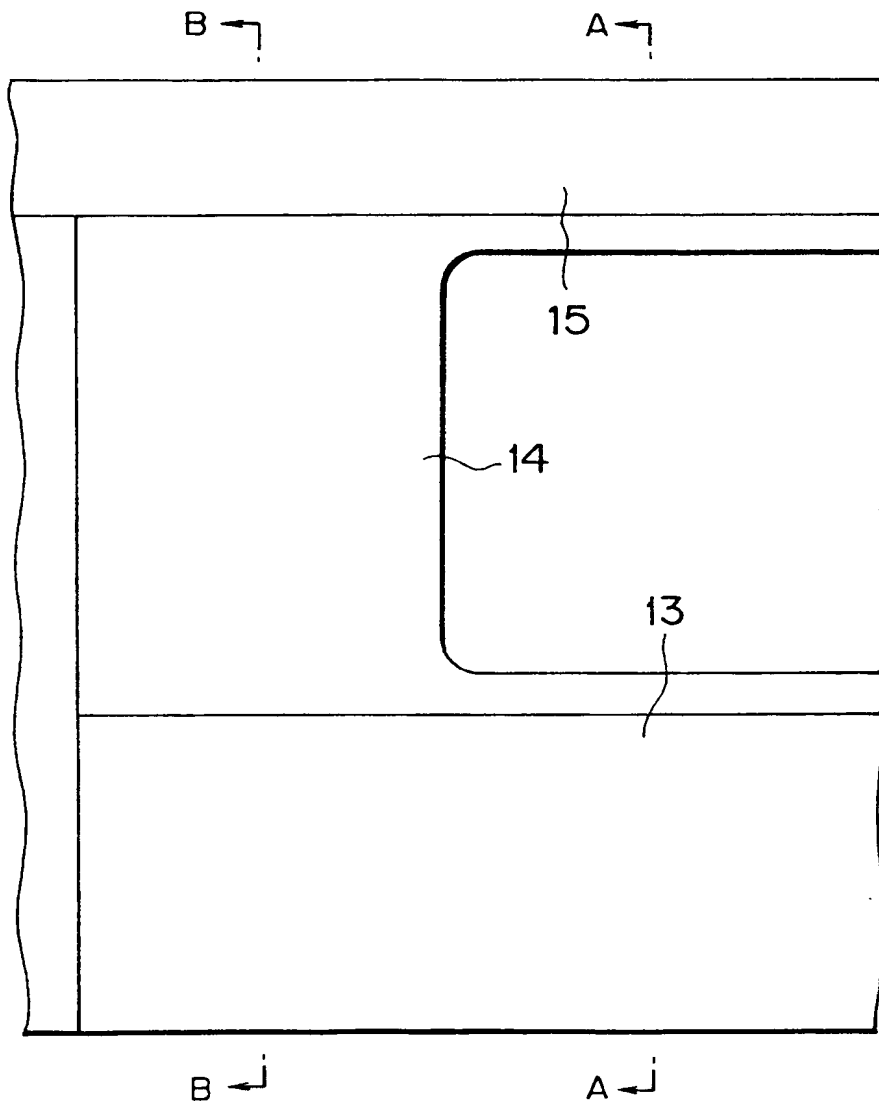


FIG.14A

PRIOR ART

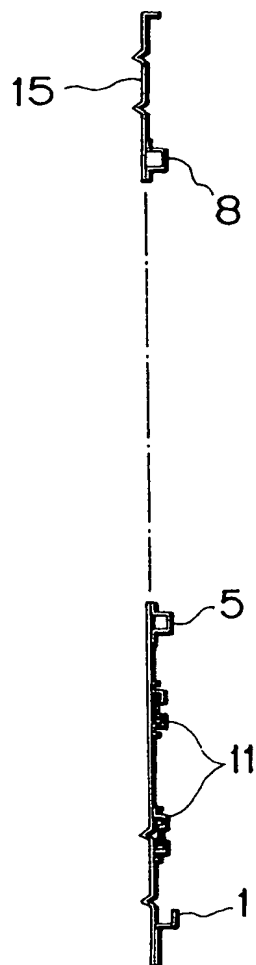


FIG.14B

PRIOR ART

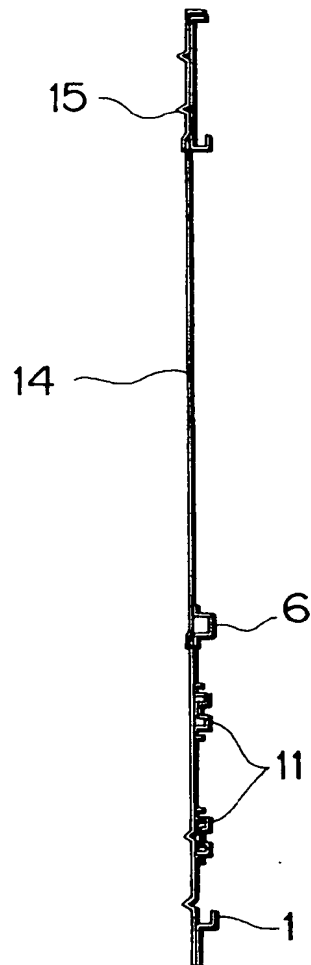


FIG.14C

PRIOR ART

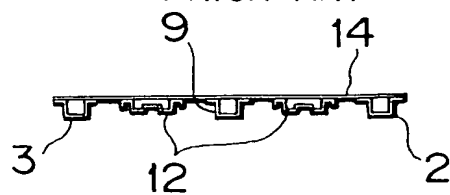


FIG. 15B
PRIOR ART

FIG. 15A
PRIOR ART

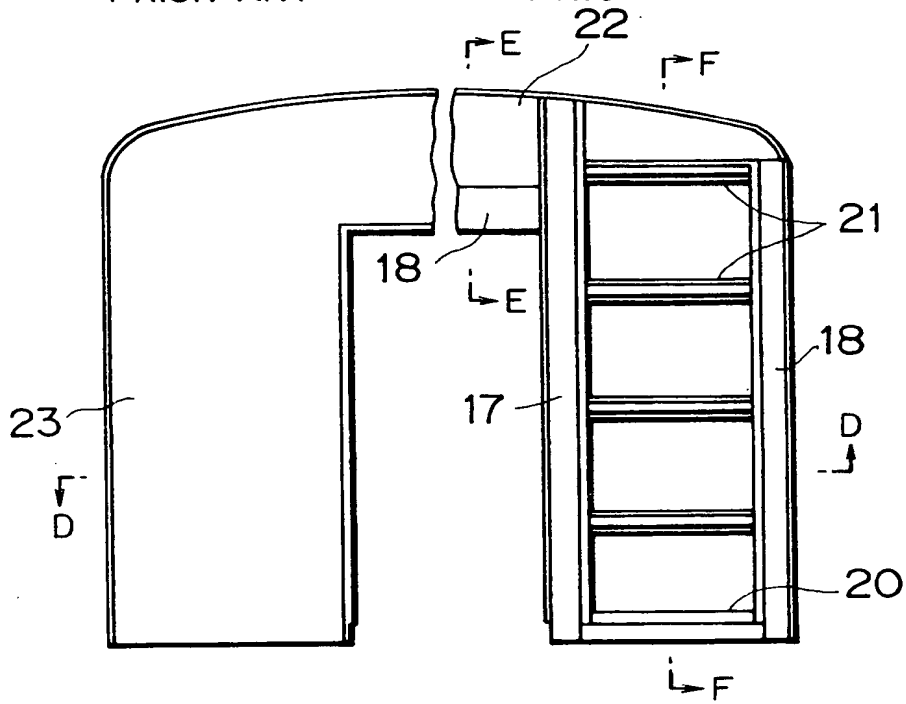


FIG. 15C
PRIOR ART

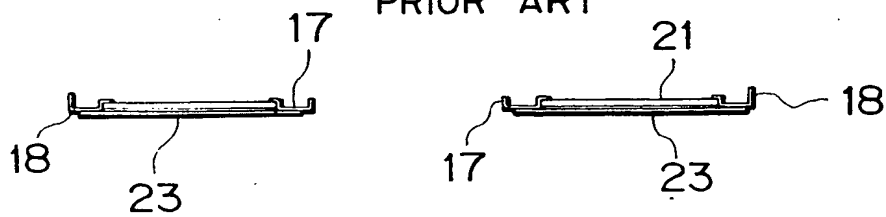


FIG.15D
PRIOR ART

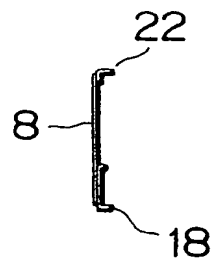
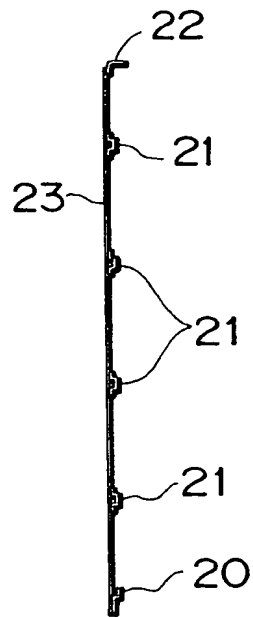


FIG.15E
PRIOR ART



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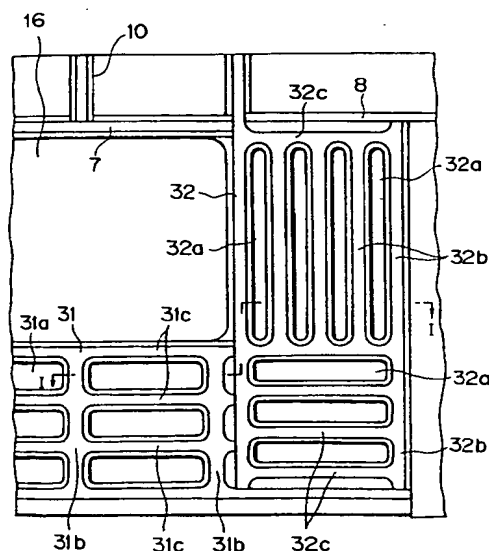
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Friedrichstrasse 31
W-8000 München 40(DE)(54) **Body structure for railway vehicle.**

(57) A side body structure for vehicles is formed of a plurality of sections. Each of the sections has a reinforcement in an integrally continuous construction. The reinforcement has a plurality of through holes (31A) which reduce total weight of the reinforcement. The reinforcement further includes a plurality of ribs formed (31B) around the holes (31A) and is securely placed together with a surface of an outer plate (15) (107).

FIG. 1A**EP 0 477 727 A3**



European Patent
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EUROPEAN SEARCH REPORT

Application Number

EP 91 11 5739

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl.5)
X	FR-A-2 528 946 (DAIMLER-BENZ & AL) * claims 1-7; figures 1-3 *	1,2,10	B61D17/08 B61D17/04 B61D17/06
A	---	4,5,6	
X	DE-A-2 707 573 (KRUPP & AL) * page 4, line 10 - page 5, line 20; figures 1-5 *	1,2,4,5	
Y	US-A-3 585 942 (SHAVER) * column 2, line 34 - column 4, line 12; figures 1-5 *	1	
Y	US-A-2 164 646 (EDAHL) * the whole document *	1	
A	RAILWAY GAZETTE INT. vol. 135, no. 8, August 1979, page 751; AN.: 'light construction'	1,2,3,8, 10,11	
			TECHNICAL FIELDS SEARCHED (Int. Cl.5)
			B61D
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 25 FEBRUARY 1992	Examiner SCHMAL R.
CATEGORY OF CITED DOCUMENTS X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document			